

LNP™ THERMOCOMP™ DX13354X compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP* Thermocomp* compound DX13354X is a colorable, glass fiber reinforced Polycarbonate resin based LDS material solution with stable plating and RF performance, providing excellent stiffness with good surface and good impact strength. The product is available for internal and external parts for Laser Direct Structuring applications.

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Good Impact Resistance		
	Good Surface Finish		
	High Stiffness		
Uses	Laser Direct Structuring		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
280°C/2.16 kg	12	g/10 min	
300°C/1.2 kg	16	g/10 min	
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	13.0	cm ³ /10min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.10 to 0.30	%	
Across Flow : 3.20 mm	0.30 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6900	MPa	ASTM D638
--	6600	MPa	ISO 527-2/1
Tensile Strength			
Break ²	90.0	MPa	ASTM D638
Break	90.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ³	2.2	%	ASTM D638
Break	2.1	%	ISO 527-2/50
Flexural Modulus			
--	6300	MPa	ASTM D790
--	6400	MPa	ISO 178
Flexural Strength	130	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength (23°C)	36	kJ/m ²	ISO 179/2U
Notched Izod Impact			
23°C	90	J/m	ASTM D256
23°C ⁴	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	500	J/m	ASTM D4812
23°C ⁵	32	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	124	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁶	126	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	120	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁷	122	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	2.2E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	1.9E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	6.1E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value		Test Method
Dielectric Constant			Internal Method
1.10 GHz	3.48		
1.90 GHz	3.46		
5.00 GHz	3.45		
Dissipation Factor			Internal Method
1.10 GHz	0.013		
1.90 GHz	0.012		
5.00 GHz	0.011		
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	270 to 295	°C	
Middle Temperature	270 to 295	°C	
Front Temperature	270 to 295	°C	
Nozzle Temperature	270 to 295	°C	
Processing (Melt) Temp	270 to 295	°C	
Mold Temperature	100 to 120	°C	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	80*10*4		

5.	80*10*4
6.	80*10*4 mm
7.	80*10*4 mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

